

Work Order ID 131135

131135

Page 1

March-26-15 1:44:26 PM

Item ID: D2938-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle LH Out, 206
 Start Date: 3/26/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1503-31 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2938	Rev C

100	HAAS CNC VERTICAL MACHINING #1	0.00							DAS 25 9-89
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100

HAAS 1
HAAS CNC vertical machine #1

Memo
Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

110	CONVENTIONAL MILLING MACHINE	0.00							DAS 25 9-89
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110

Mill Conv
Conventional Milling Machine

Memo
Machine Keyway and inspect per attached dimension sheet

120	QC1- Inspection performed by CMM	0.00							
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120

QC
Quality Control

Memo
0.00

2 15-4-30
 2 15-4-30
 2 15/05/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00
150 M 131545
Powdercoat Memo 0.00
Powder Coating START TIME: 10:10 OVEN TEMPERATURE: 2 15-5-12.
300° FINISH TIME: 10:40

DQA: _____ Date: _____



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March-26-15 1:44:26 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAG 38 9-89
160									
QC	Memo	0.00							
Quality Control									MAY 12 2015
170	Identify as per dwg & Stock Location: <u>539S</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									2 DAG 27 9-89 MAY 14 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									MLJ MAY 15 2015 MLJ MAY 14 2015

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Picklist Print

March-26-15 1:44:26 PM

Page 1

Work Order ID: 131135

131135

Parent Item: D2938-1

D2938-1

Parent Item Name: Saddle LH Out, 206

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	21.0000	1	2			

D6101-003

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT044

21

120394

9

128906

2

129920

10

2 ofc 2015-04-29

DQA: _____ Date: _____



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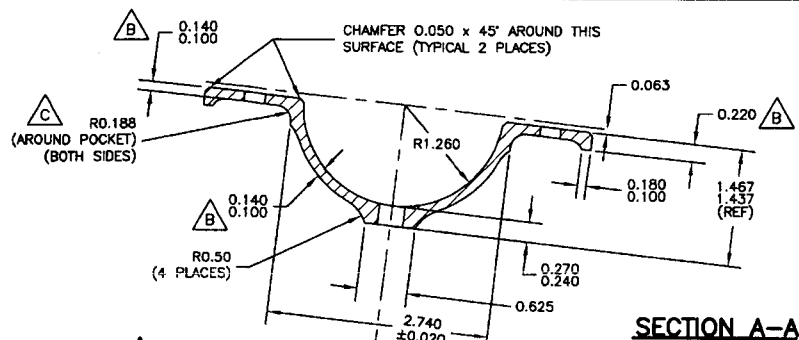
DART AEROSPACE LTD	Work Order:	131135
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

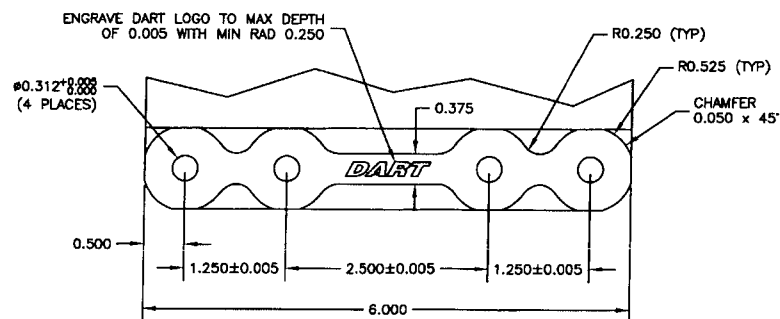
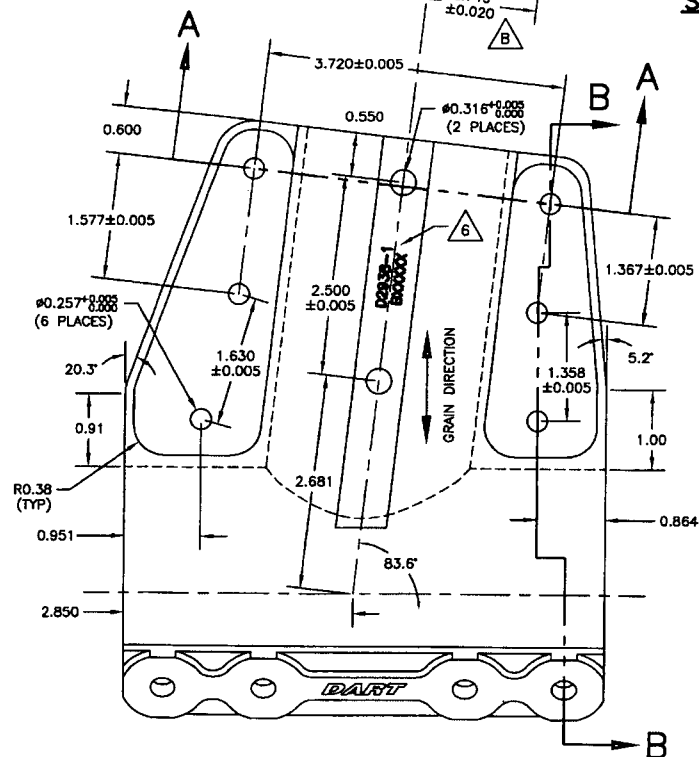
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.134	.134				
B	0.100	0.140		.134	.134				
C	0.100	0.140		.126	.125				
D	0.210	0.230		.223	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.512	.512				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.239	.239				
N	0.100	0.140		.123	.120				
O	0.540	0.560		.548	.549				
P	0.490	0.510		.500	.501				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.743	2.743				
S	0.240	0.270		.255	.249				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.257	1.259				
Y	1.565	1.585		1.572	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>JL</u>	Audited by: <u>DA</u>	DAS
Date: <u>15-4-30</u>	Date: <u>15/05/03</u>	08
		9-89

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

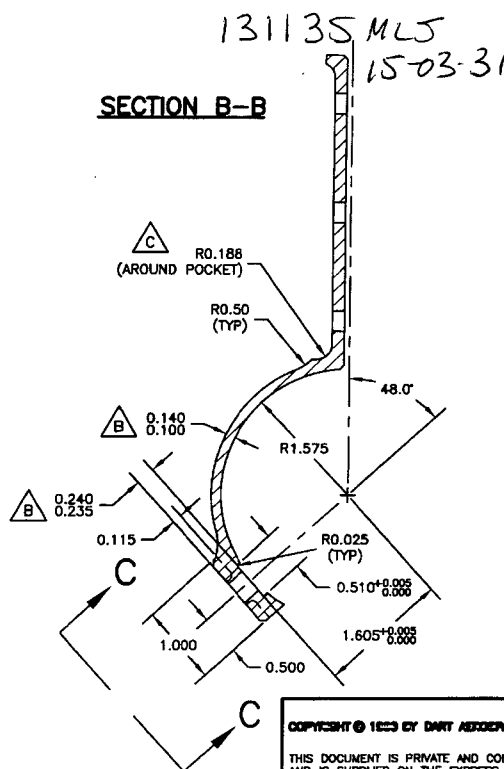


SECTION A-A



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	APPROVED	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	06.11.09	TITLE SADDLE OUTSIDE

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

SHEET 1 OF 1
SCALE
2:3



Part Number: D2938-1	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 131135

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual			
A	0.120	0.020 -0.020	0.134	0.134			
B	0.120	0.020 -0.020	0.134	0.134			
C	0.120	0.020 -0.020	0.126	0.125			
D Distance YZ	0.2200	0.0100 -0.0100	0.2216	0.2247			
E Distance XY	1.2500	0.0050 -0.0050	1.2497	1.2497			
F Distance XY	1.2500	0.0050 -0.0050	1.2499	1.2491			
G Distance XY	2.5000	0.0050 -0.0050	2.4996	2.4995			
H	0.510	0.005 0.000	0.512	0.512			
I Distance XY	1.5770	0.0050 -0.0050	1.5771	1.5783			
J Distance XY	2.5000	0.0050 -0.0050	2.4989	2.4995			
K Diameter	0.2570	0.0050 -0.001	0.2570	0.2571			
L Diameter	0.3120	0.0050 -0.001	0.3131	0.3126			
M	0.235	0.005 0.000	0.239	0.239			
N Distance YZ	0.1200	0.0200 -0.0200	0.1232	0.1264			
O Distance XY	0.5500	0.0100 -0.0100	0.5517	0.5503			
P Distance XY	0.5000	0.0100 -0.0100	0.5006	0.5013			
Q Distance XY	3.7200	0.0050 -0.0050	3.7185	3.7196			
R Distance XY	2.7400	0.0200 -0.0200	2.7467	2.7470			

Measured by:
Mathieu Lamarche

Date:
2015-5-6

Audited by:

Date:



Part Number: D2938-1	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 131135

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual			
S	0.255	0.015 -0.015	0.255	0.249			
T	0.140	0.020 -0.020	0.140	0.140			
U Distance XY	1.6300	0.0050 -0.0050	1.6305	1.6299			
V Distance XY	1.3670	0.0050 -0.0050	1.3676	1.3670			
W Diameter	0.3160	0.0050 -.001	0.3150	0.3156			
X	1.260	0.010 -0.010	1.257	1.259			
Y	1.575	0.010 -0.010	1.572	1.573			
Z Radius	0.1880	0.0100 -0.0100	0.1932	0.1935			

Measured by:
Mathieu Lamarche

Date:
2015-5-6

Audited by:

Date: